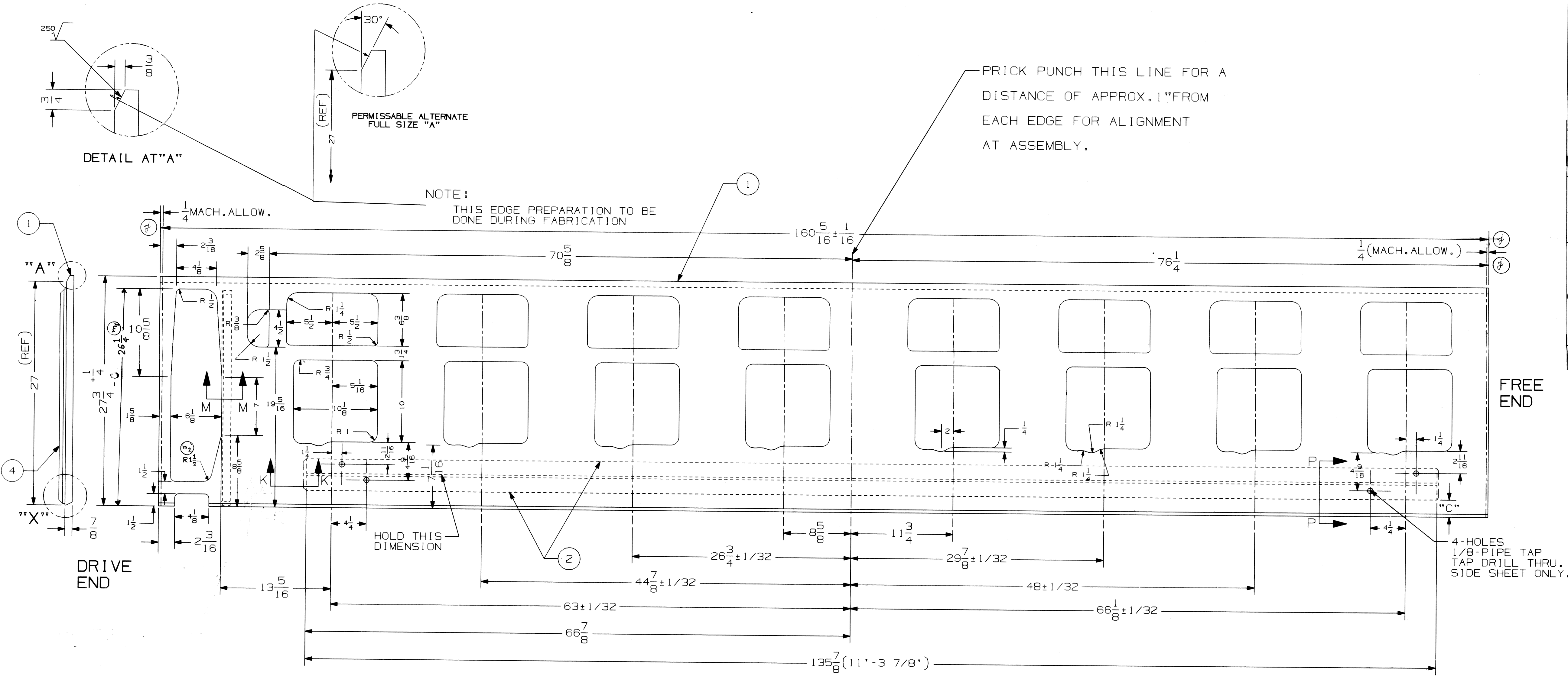
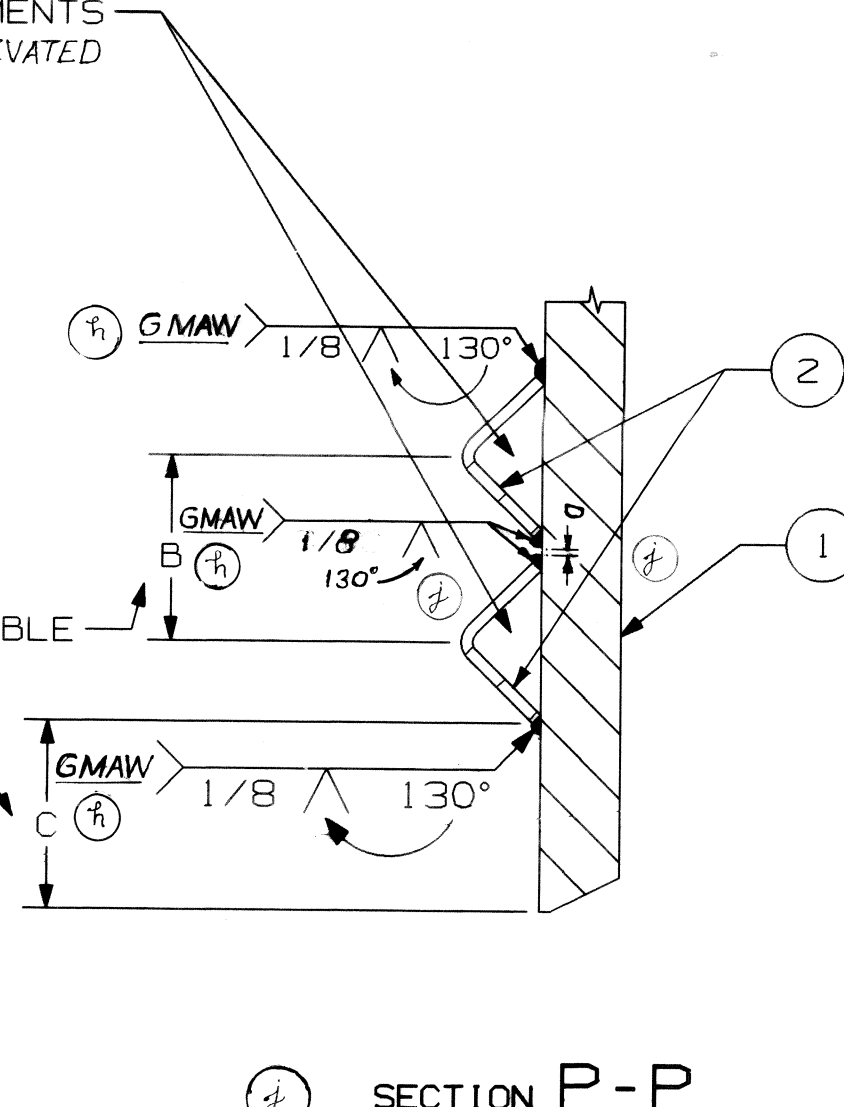
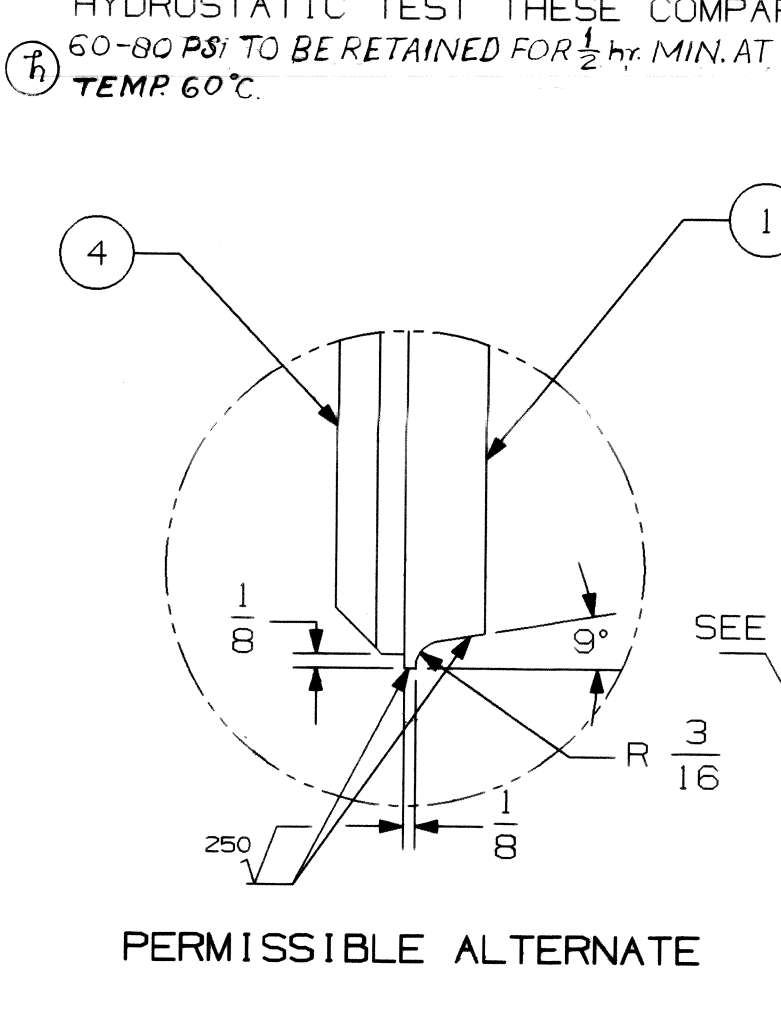
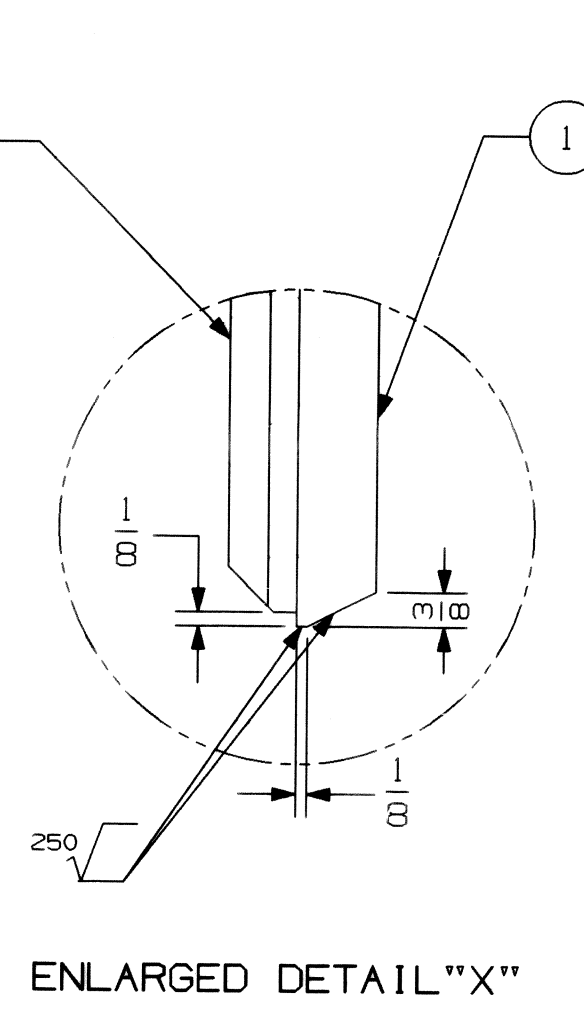
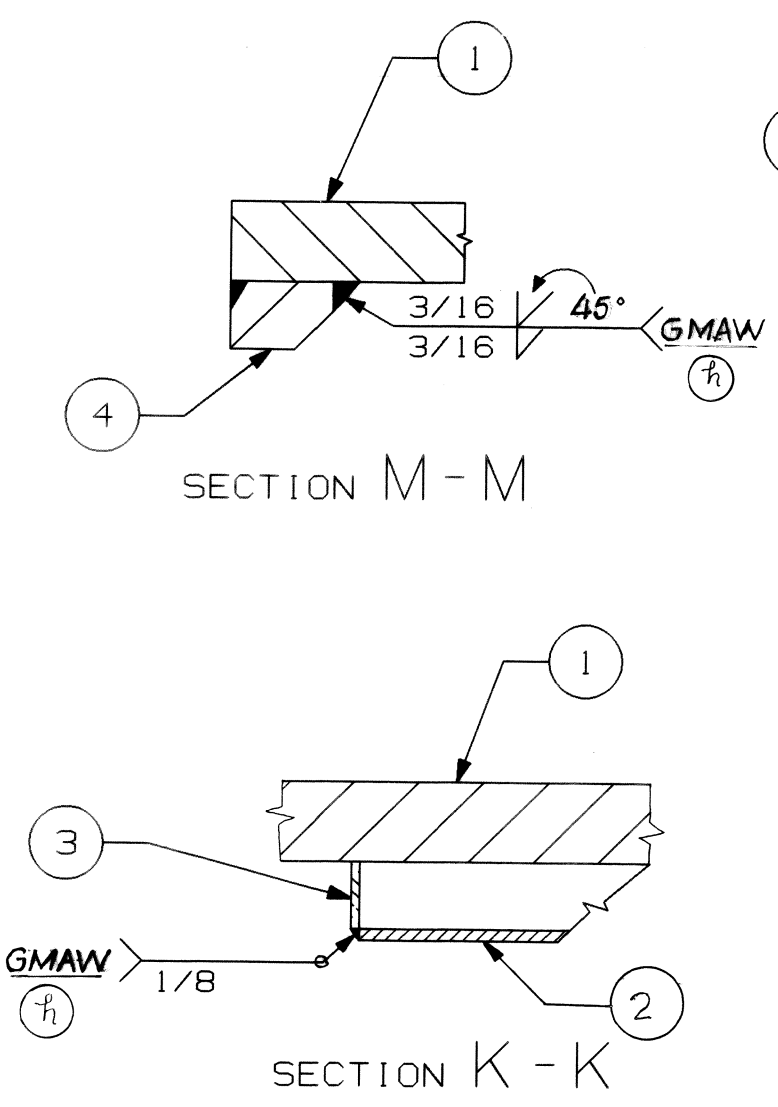


SC 411



ALT. NO.	ALTERATION	VERIFIED BY SSE/D	INITIAL
①	DRAWING REDRAWN		
②	①) PRESSURE 60-80 PSI TO BE RETAINED FOR 1/2 hr. MIN. AT ELEVATED TEMP 60°C WAS 35-40 PSI. GMAW WELDS WAS T3 TYPE. REF: C/N NO. CDE/ENG/16 CYL/12 CYL/2013/02 DT. 02.02.2002.		
③	1. ADDED GAP 'D' BETWEEN TWO ANGLES AND WELDING REVISED. 2. DIMENSION LINE CORRECTED.		
④	PART NO. 11151420 HAS BEEN CHANGED TO PART NO. 11151432.		
⑤	MISC-119 WAS 15-2062 G.B. REF: Ed. No. 1117, DT. 23.11.04.		
⑥	1. DIM. 26 3/4 ADDED. 2. DIM. R 1 1/2 ADDED.		
⑦	1. DIM. 11 7/16 AND 1 1/16 DELETED. 2. 1-HOLE 1 3/8 DIA DRILL THRU DELETED. REF: C/N NO. CDE/ENG/16 CYL/12 CYL/2013/02 DT. 02.02.13.		



HYDROSTATIC TEST THESE COMPARTMENTS 60-80 PSI TO BE RETAINED FOR 1/2 hr. MIN. AT ELEVATED TEMP 60°C.

- NOTE :-
1. ALL CUT SURFACES UNLESS OTHERWISE NOTED.
  2. DIMENSION SHOWN DO NOT INCLUDE ALLOWANCE FOR CUTTING OR WELDING SHRINKAGE.
  3. SHOT BLAST ITEM 2 BEFORE WELDING.

TABLE

ANGLE USED	"B"	"C"	"D" (GAP)
1 1/4 x 1 1/4 x 1/8	1 31/32	1 5/8	13/64
35mm x 35mm x 5mm	2 1/4	1 1/8	19/64

ALL DIMS. ARE IN INCHES OTHERWISE NOTED.  
IF TOLERANCES NOT STATED FRACTIONAL MACHINING DIMENSIONS ALLOW ±0.010.  
DO NOT SCALE THE PRINT.  
ISSUING AUTHORITY : SSE/RECORDS

THIS DRAWING IS A PROPERTY OF ICM/INDIAN RAILWAYS AND ANY UNAUTHORIZED USE OF THE DRAWING WILL BE CONSIDERED ILLEGAL AND ICM/INDIAN RAILWAYS WILL HAVE RIGHT TO INITIATE LEGAL PROCEEDINGS AGAINST THE DEFAULTERS.

APPROVED BY: [Signature] SME/D  
ASSLY. PART NO. 10020019

NO. OFF	DESCRIPTION & DIMENSION	ITEM	PART NO.	DRAWING NO.	MATERIAL	SPECIFICATION
	1 WELD STRIP	4	10191203	31071298-1		
	4 END SEAL	3	10190120	31071555		
	2 ANGLE 1 1/4 x 1 1/4 x 1/8 Lg.	2	11151432			IS: 226 Gr. B
	1 SIDE PLATE	1	10191240	31B71556-1	STL. PL.	MISC-119

GROUP: WELDED CYLINDER BLOCK  
SUPERSEDED BY: [Blank]  
SUPERSEDES: ALT. "P"

SCALE: [Blank] VERIFIED BY SSE/D: [Signature]

PROJECTION: [Blank] CHD. [Blank] DRN. [Blank]

ALT. ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺

**SIDE SHEET (R.S.)**

DIESEL LOCOMOTIVE WORKS VARANASI

PART NO. 10020044  
DRG. NO: 31B71556  
UG-SOLID